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A.D. 1868, 11th JUNE. N° 1917.

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SPECIFICATION

OF

ALEXANDER SOUTHWOOD STOCKER.

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FEEDING BOTTLES, &c.

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LONDON:

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1868.







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A.D. 1868, 11<sup>th</sup> JUNE. N° 1917.

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**Feeding Bottles, &c.**

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LETTERS PATENT to Alexander Southwood Stocker, of Lamb's Conduit Works, Artillery Street, Horsleydown, in the County of Surrey, for the Invention of "IMPROVEMENTS APPERTAINING TO INFANTS' FEEDING BOTTLES, AND IN THE MANUFACTURE, COMBINATION, AND EMPLOYMENT OF THE WHOLE OR PART OF THE ARTICLES TO BE USED THEREWITH, PART OF WHICH MAY ALSO BE BENEFICIALLY EMPLOYED FOR OTHER PURPOSES."

Sealed the 8th December 1868, and dated the 11th June 1868.

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PROVISIONAL SPECIFICATION left by the said Alexander Southwood Stocker at the Office of the Commissioners of Patents, with his Petition, on the 11th June 1868.

I, ALEXANDER SOUTHWOOD STOCKER, of Lamb's Conduit Works,  
5 Artillery Street, Horsleydown, in the County of Surrey, do hereby declare the nature of the said Invention for "IMPROVEMENTS APPERTAINING TO INFANTS' FEEDING BOTTLES, AND IN THE MANUFACTURE, COMBINATION, AND EMPLOYMENT OF THE WHOLE OR PART OF THE ARTICLES TO BE USED THEREWITH, PART OF WHICH MAY ALSO BE BENEFICIALLY EMPLOYED FOR OTHER PURPOSES," to  
10 be as follows:—

This Invention relates to producing out of certain kinds of sheet metal certain covers with screws or their equivalents provided thereon or therein by the aid of external and internal pressure effected by

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*Stocker's Improvements in Infants' Feeding Bottles, &c.*

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mandrils, hubs, and following dies and tools, and the employment of them with feeding bottles and such other receptacles as are technically called and known in the trade as "blow" or "burst-offs," also in providing in such covers as are intended to be applied to and used with feeding bottles holes through which the infant's ordinary sucking tubes are to 5 pass, such holes being eyeleted or other provisions made so as to prevent the abrasion of the india-rubber tube or other material or article necessary to be used therewith; also in the manufacture and employment of round discs or other shaped pieces of vulcanized india-rubber or other elastic material, previously prepared in such manner as to facilitate 10 suction while the vessel is being used; such conveniently shaped pieces of india-rubber or other material are intended to be held or gripped by the aid and action of the screws or their equivalents on the "blow" or "burst-off" bottles effected thereon by blowing, and the screws or their equivalents produced on the cover to be employed therewith. These 15 desirably shaped pieces receive their configurations in their entirety at one operation by the aid of suitable cutting apparatus.

It is desirable for my Invention that the metal out of which the covers are to be made be elastic before their manufacture has been commenced upon, as also the partially made cover when at a stage in readiness to 20 receive the screw or its equivalent to be provided thereon or therein. Covers so made will be found most convenient and useful and exceedingly economical when applied to "blow" or "burst-off" bottles generally; in these cases the holes referred to in the crowns of the covers will not be made therein. 25

I also manufacture, combine, and employ with glass or other metal screw or other covers to be employed with feeding bottles vulcanized india-rubber attached thereto globularly or otherwise so shaped as to rest against the infant's features, thereby rendering greater comfort when in use. 30

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**SPECIFICATION** in pursuance of the conditions of the Letters Patent, filed by the said Alexander Southwood Stocker in the Great Seal Patent Office on the 11th December 1868.

**TO ALL TO WHOM THESE PRESENTS SHALL COME, I, ALEXANDER SOUTHWOOD STOCKER, of Lamb's Conduit Works, Artillery Street, 35 Horsleydown, in the County of Surrey, send greeting.**



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WHEREAS Her most Excellent Majesty Queen Victoria, by Her Letters Patent, bearing date the Eleventh day of June, in the year of our Lord One thousand eight hundred and sixty-eight, in the thirty-first year of Her reign, did, for Herself, Her heirs and successors, give  
5 and grant unto me, the said Alexander Southwood Stocker, Her special licence that I, the said Alexander Southwood Stocker, my executors, administrators, and assigns, or such others, as I, the said Alexander Southwood Stocker, my executors, administrators, and assigns, should at any time agree with, and no others, from time to time and at all  
10 times thereafter during the term therein expressed, should and lawfully might make, use, exercise, and vend, within the United Kingdom of Great Britain and Ireland, the Channel Islands, and Isle of Man, an Invention for "IMPROVEMENTS APPERTAINING TO INFANTS' FEEDING BOTTLES, AND IN THE MANUFACTURE, COMBINATION, AND EMPLOYMENT OF THE WHOLE OR  
15 PART OF THE ARTICLES TO BE USED THEREWITH, PART OF WHICH MAY ALSO BE BENEFICIALLY EMPLOYED FOR OTHER PURPOSES," upon the condition (amongst others) that I, the said Alexander Southwood Stocker, my executors or administrators, by an instrument in writing under my, or their, or one of their hands and seals, should particularly describe and ascertain  
20 the nature of the said Invention, and in what manner the same was to be performed, and cause the same to be filed in the Great Seal Patent Office within six calendar months next and immediately after the date of the said Letters Patent.

NOW KNOW YE, that I, the said Alexander Southwood Stocker, do  
25 hereby declare the nature of my said Invention, and in what manner the same is to be performed, to be particularly described and ascertained in and by the following statement thereof, that is to say :—

This Invention relates to producing caps or covers out of certain kinds of metal or alloys of a yielding, unridged, pliant nature, say block  
30 tin, pewter, Britannia, or such like metal as will readily conform to and receive screws or their equivalents provided thereon or therein by external and internal pressure by the aid of an india-rubber mandril or plug in combination with internally screwed dies or matrixes, made in two parts, and to follow each other with a view to facilitate the release  
35 of the caps or covers therefrom after they have been shaped, as well as for operating upon them with greater rapidity. This part of my Invention is an improvement upon a Patent granted to me, No. 2387,



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A.D. 1867, and I proceed as follows:—When I have these caps or covers produced in any manner now well known and of desirable depth and diameter and in their blank or unscrewed state, I place them in dies which have screwed holes therein of a measurement both in depth and diameter desirable for the intended screw to be given to the cap or 5 cover when operated upon; I then place in the cap or cover a mandril or plug of india-rubber fitting or nearly so the orifice of the die and somewhat higher than it; I then place them together into a turned box permanently fixed in a fly press; I then by the aid of a flat blank forcer or plunger give the rubber a smart blow which screws the cap or 10 cover, the die is then lifted out of the box, when the cap or cover may be readily released, the die again charged with another blank and the rubber, and so on the operation repeated. I use a series of these dies following each other for the purpose of despatch. Each die is accurately although loosely fitted into the permanent box so that when 15 one has been used another is placed by hand therein immediately, and so on they follow in rotations. Caps or covers composed of metal of this category may be made and screwed other than in the manner I have mentioned without departure from my Invention, but I prefer this mode of procedure on account of economy and good workmanship. When 20 these caps or covers are applied to and employed with infants' feeding bottles central holes are made in their crowns or centres for the passage of and holding therein the infant's ordinary sucking tubes, as well also of holding, combining, and employing therewith discs made according to my Invention of india-rubber, substantially as and for the purposes 25 described in the Specification of my Patent, No. 675, A.D. 1868. This rubber is before being cut into discs prepared or treated according to my Invention in the following manner:—I pass it one or more times through or between a pair of rollers, one of which is rigid on its surface and provided with sharp pointed pins or spikes fixed therein of suitable 30 lengths and diameter and at proper distances apart, whilst the surface of the other roller is rendered elastic by coating it with plain rubber or other suitable soft material. The sheet after having been operated upon will assume a porous-like texture; it is then to be cut at one operation into discs having desirable holes in the centre for the purpose of holding 35 therein and employing therewith the sucking tubes before mentioned. These discs may be cut out by any of the well-known appliances at present in use. If desired the sheet of rubber may be similarly punctured by the aid of piercing tools worked in any convenient manner



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fixed in a fly press or otherwise, or the discs may be similarly punctured by hand or in any other convenient manner out of plain unpunctured rubber after they have been cut into discs, but I prefer the mode of procedure first mentioned. Sheet rubber so prepared will be very useful  
5 for various purposes.

Another part of my Invention consists in the manufacture attaching to combining and employing with glass or other metal, or other caps or covers to be employed with infants' feeding bottles pieces of vulcanized india-rubber of globular or other convenient form so as to  
10 rest against the infant's features in place of the cold and rigid substances now in general use for that purpose, rendering it thereby more inviting by affording much greater comfort when in use. It is obvious that such may be applied to screwed covers, such, for example, as those referred to in my Patent, No. 675, A.D. 1868. The rubber being plastic  
15 may be moulded into the desirable shapes, thicknesses, and forms required by the same means and process as expressed in the Specification of the Patent last referred to. The rubber when moulded, vulcanized, and treated as in general may be drawn over or on to the caps or covers before mentioned when their own elasticity will collapse its intended  
20 resting place, fixing and holding itself firmly thereon; the cap or cover may then be screwed on to and off the bottle most conveniently. A provision is made in the crown or centre of the rubber, as also in the crown or centre of the cap, for the purpose of holding therein and employing therewith portable teats as well as the ordinary appendages  
25 now generally used with feeding bottles, and in order to cause a free draught or suction the crown or top surface of the cap or cover is perforated in like manner herein-before explained. Vulcanized india-rubber caps or covers may be moulded with screwed metal rings therein for the purpose of giving strength and rigidity to that part which screws  
30 on to and off the blown or burst off screwed feeding bottles; the india-rubber cap or cover will thus become lined with metal at that part while the rubber itself will conform to and become screwed both inside and outside by both simultaneously being acted upon and embraced by the dies and pressure herein-before mentioned; or these caps or  
35 covers may be made in their entirety, care being taken that the material is compounded of sufficient stubborn texture to resist the screwing on to and off the blown or burst off screw bottles, to and with which they are intended to be applied and employed. In this case the metal screwed ring may be dispensed with.

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These caps or covers are an improvement upon my Patent, A.D. 1868, No. 675. They will have eyelets fixed therein in the same manner and for the purpose as therein stated. These caps or covers will be more securely held on to the neck of the bottle by being screwed thereon, which I have found from experience is much to be preferred. 5

In witness whereof, I, the said Alexander Southwood Stocker, have hereunto set my hand and seal, this Eleventh day of December, in the year of our Lord One thousand eight hundred and sixty-eight.

ALX<sup>R</sup>. S. STOCKER. (L.S.) 10

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LONDON:

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